

Work Order ID 54823

December 22, 2009 1:28:44 PM



Page 1

Item ID: D3695-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stopper

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *CZ*

Date: *09/12/23* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3695

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.25 " long

and 10/01/12

4 0

PTO

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA733 Rev: *AA* & Dwg D3695 Rev: *C* 112-Deburr
per dwg D3695 113-TAP FOR 3/8"-16 HELICOIL

and 10/01/13

4 2

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00


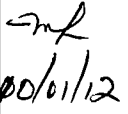
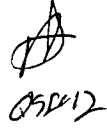
Quality Control

and 10/01/13

4 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3695-3 PAR #: N/A Fault Category: Machine NCR: ☒ Yes No PQA: 15 Date: 10.01.19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 79 Date: 10/01/26

| NCR: <u>54823</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|--|---|---|---------------------------|--|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/01/12 | 110 | 2 parts scrap, 1 dim. too big the 2.313 was 2.333 and dim. 1.23 was 1.197 1. R.C. program error. |  | scrap and destroy replace Batch M113403 Qty 2 |  10/01/12 | S 10/01/13 |  05/01/12 | S 10/01/13 |
| | | 2. R.C. operator error put the cutter comp at the wrong place. | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 54823

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Page 2

Item ID: D3695-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stopper

Start Date: 1/05/10

Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A 10/01/13

4

✓

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/01/14

(X4)

Ø

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11112588

0.00

=> M 10/01/14

(X4)

✓

Powdercoat

Memo

Powder Coating

*****MASK ALL HOLES AS PER DWG

D3695*****[START TIME:

3:30pm OVEN TEMPERATURE: 3:00pm FINISH

TIME: 320-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 54823

December 22, 2009 1:28:49 PM



Page 3

Item ID: D3695-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stopper

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 10-01-15

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: *255*

0.00

Memo

0.00

10-1-15 (40) SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/01/18 98**MF 10-1-15*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:28:43 PM

Page 1

Work Order ID: 54823

Parent Item: D3695-3

Parent Item Name: Stopper

Comments:

Start Date: 1/05/10

Required Date: 1/15/10

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6B2.500X03.50 0 | | Purchased | No | | | | f | 34.8150 | 1.4807 | | | |



6061-T6 Bar 2.50 x 3.50



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 34.815 | |
| 102838 | 13.1 | |
| 110936 | 1.03 | |
| 111700 | 1.365 | |
| → 113403 | 19.32 | |

1.4807

✓ 12/01/02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 54823 |
| Description: Slider | | Part Number: | D3695-3 |
| Inspection Dwg: D3695 | Rev: C | Page 1 of 1 | |

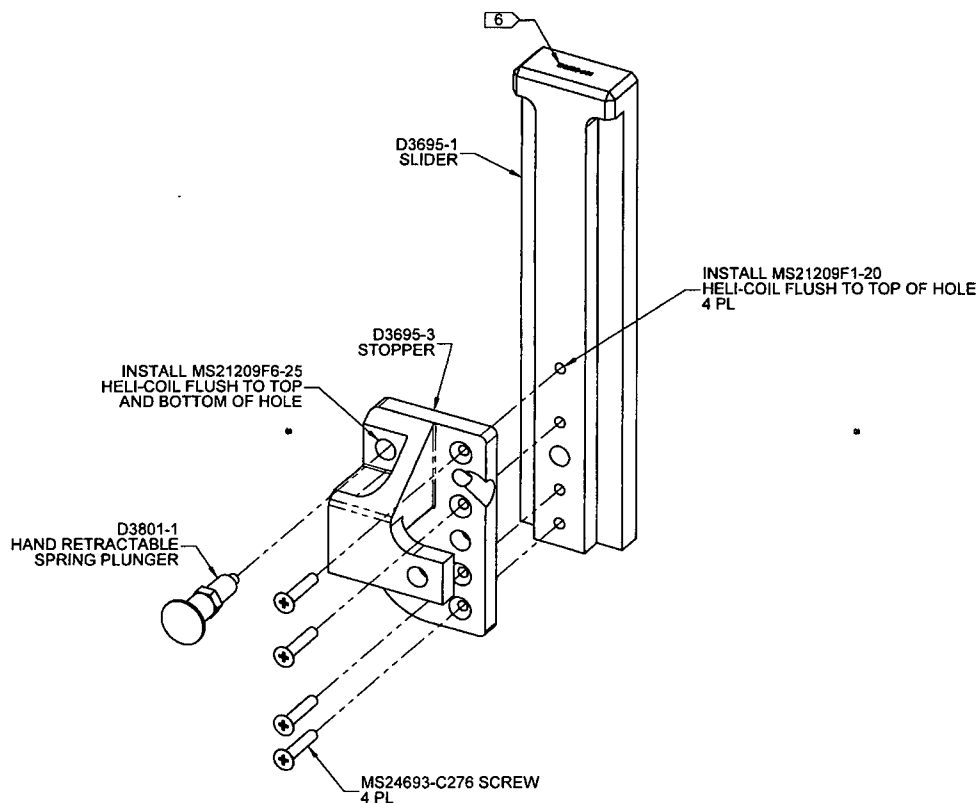
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 0.625 | +/-0.010 | .629 | ✓ | | | |
| 1.063 | +/-0.010 | 1.065 | ✓ | | | |
| Ø0.391 | +0.006/-0.001 | Ø.393 | ✓ | | | |
| Ø0.194 | +0.005/-0.001 | Ø.197 | ✓ | | | |
| Ø0.425 x 100° | +/-0.010 x 0.5° | Ø.430 x 100° | ✓ | | | |
| Ø0.386 | +0.006/-0.001 | Ø.388 | ✓ | | | |
| 0.450 | +/-0.010 | .448 | ✓ | | | |
| 2.025 | +/-0.010 | 2.024 | ✓ | | | |
| 0.83 | +/-0.010 | .830 | ✓ | | | |
| 0.575 | +/-0.010 | .573 | ✓ | | | |
| 0.500 | +/-0.010 | .498 | ✓ | | | |
| Ø0.328 | +0.006/-0.001 | Ø.332 | ✓ | | | |
| 0.500 | +/-0.010 | .499 | ✓ | | | |
| 1.813 | +/-0.010 | 1.811 | ✓ | | | |
| 2.62 | +/-0.030 | 2.620 | ✓ | | | |
| 1.075 | +0.010/-0.000 | 1.079 | ✓ | | | |
| 0.38 | +/-0.030 | .369 | ✓ | | | |
| 2.313 | +/-0.010 | 2.312 | ✓ | | | |
| 4.00 | +/-0.030 | 4.001 | ✓ | | | |
| 1.83 | +/-0.030 | 1.827 | ✓ | | | |
| 1.23 | +/-0.030 | 1.225 | ✓ | | | |
| 2.25 | +/-0.030 | 2.250 | ✓ | | | |
| 0.650 | +/-0.010 | .652 | ✓ | | | |
| 0.279 | +/-0.010 | .269 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|---------------------|--------------------|--------------------|----------|----------------------------|-----|
| Measured by: | <i>[Signature]</i> | Audited by: | H.A | Prototype Approval: | N/A |
| Date: | 10/01/12 | Date: | 10/01/13 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------------|--------------------|
| A | 09.05.11 | New Issue | KJ <i>[Signature]</i> | <i>[Signature]</i> |



D3695-041 SLIDER ASSEMBLY

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|---------------------------------|
| 1 | X | D3695-041 | SLIDER ASSEMBLY |
| 11 | 1 | D3695-1 | SLIDER |
| 12 | 1 | D3695-3 | STOPPER |
| 15 | 1 | D3801-1 | HAND RETRACTABLE SPRING PLUNGER |
| 21 | 4 | MS21209F1-20 | HELI-COIL, SCREW LOCKING (RED) |
| 22 | 1 | MS21209F6-25 | HELI-COIL, SCREW LOCKING (RED) |
| 23 | 4 | MS24693-C276 | SCREW |

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C209112123

RELEASED
9/62/65 NTP

| C | UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{±0.005} WERE 1.81 AND 1.063 ^{±0.005} (ZN B8-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY. | MB | 08.11.04 |
|------------|---|----|----------|
| B | P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING | MB | 08.06.26 |
| A | NEW ISSUE | MB | 08.03.14 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>LB</i> | | |
| DRAWN | <i>LB</i> | | |
| CHECKED | <i>LB</i> | | |
| MFG. APPR. | <i>LB</i> | | |
| APPROVED | <i>LB</i> | | |
| DE APPR. | <i>LB</i> | | |
| DATE | 08.11.04 | | |

D3695-041 NOTES:

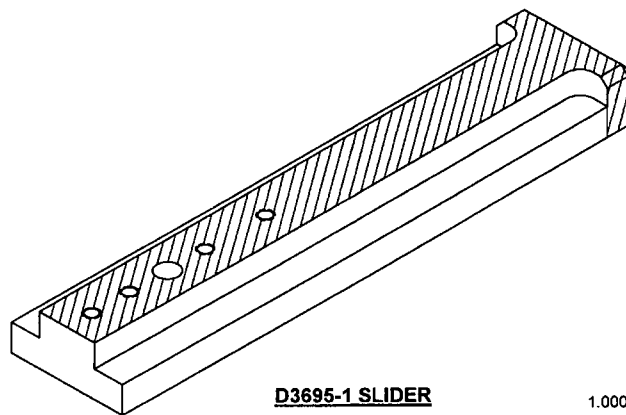
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

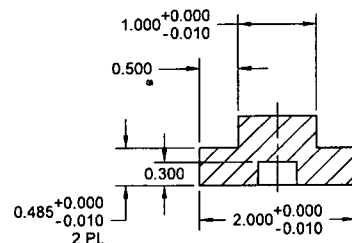
DRAWING NO. **D3695** REV. C
SHEET 1 OF 3

TITLE **SLIDER ASSEMBLY** SCALE NTS

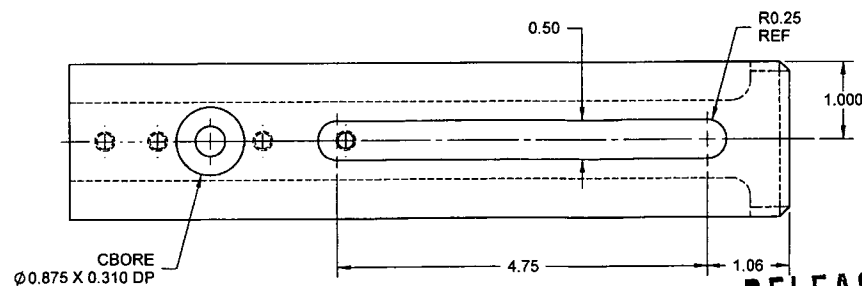
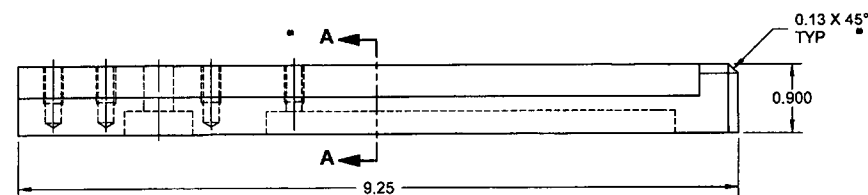
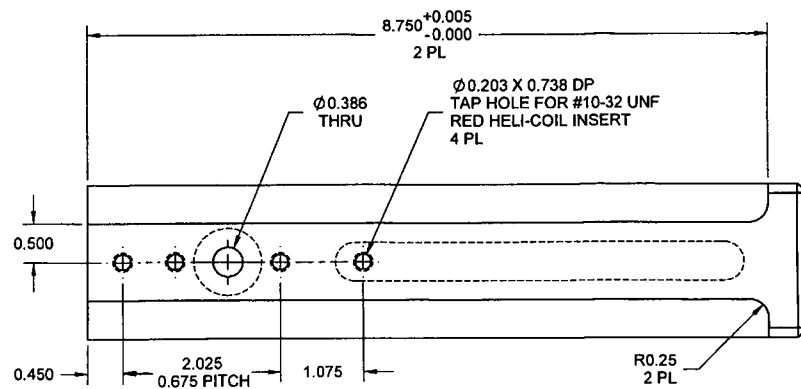
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D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

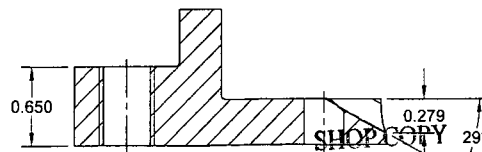
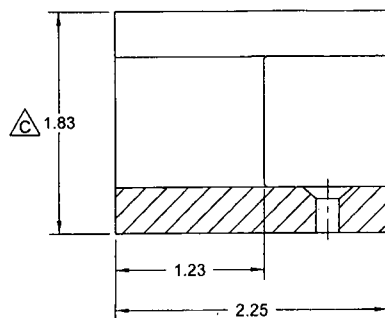
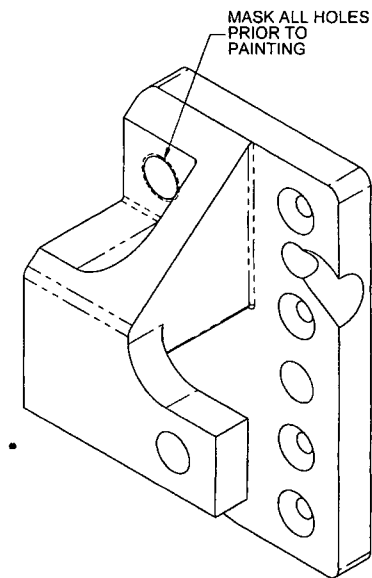
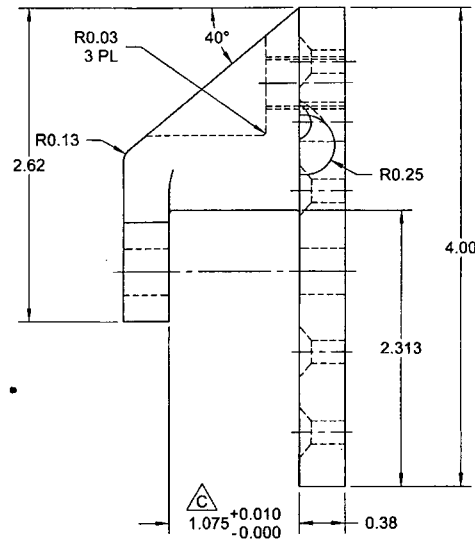
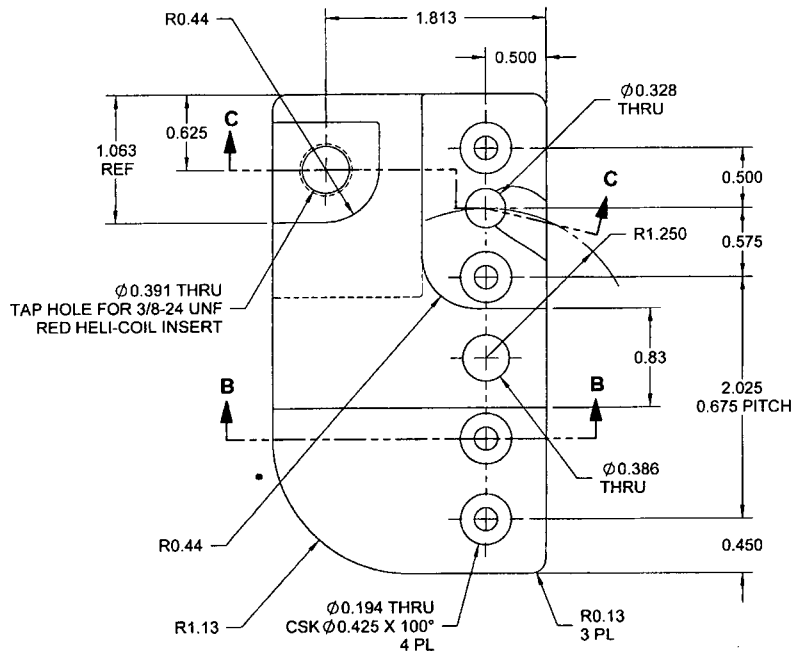
- 1) MATERIAL: 6061-T6 (OR 6061-T6511/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDLEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54823

RELEASED
09/02/05 177

| | | | |
|------------|----------|-----------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3695 | REV. C |
| MFG. APPR. | | | SHEET 2 OF 3 |
| APPROVED | | TITLE SLIDER ASSEMBLY | SCALE NTS |
| DE APPR. | | | |
| DATE | 08.11.04 | | |

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D3695-3 STOPPER

RELEASED
 07/05/05

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6511/-T6510/-T6511/-T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANTEX (4.3.5.6) PER DART
 QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

| | | | |
|--|--------------------|--|--------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD | |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3695 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SLIDER ASSEMBLY | NTS |
| DATE | 08.11.04 | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
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